SCHNEEBERGER

Tap M1.6 Z2

A10-020

The manufacturing cycle includes the loading and dressing cycle for conventional wheels for flute and thread grinding. After further research in wheel technology the cycle time could be reduced. The thread is dressed with a form roll. For those small taps a support is recommended.

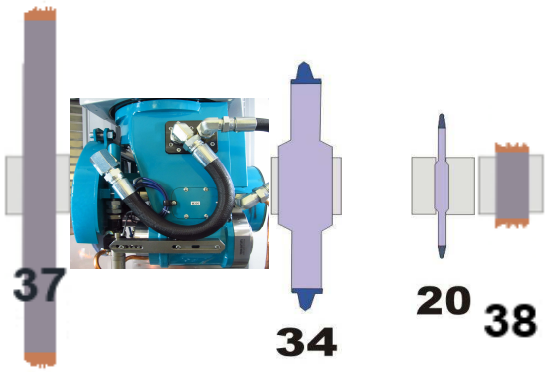
1. Cycletime for Production

Tool specifications M1.6, flutelength 9, Helix 0º Material HSSE							
Operations	Loading	Flute	Thread rough	Thread fine	Chamfer	dress flute	dress thread
Feed [mm/Min]		1600	12000	12000	12000	100	100
Power [kW]		6	4	4	4	1	1
Cutting feed [m/s]		60	65	65	65	24	24
Used wheels		34	37	37	37	20	38
Grinding time [s]	20	13	18	11	13	16	28
Total cycle time	1 Min 59						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø180 DXF A150
37 Ø400 1A1 A300
20 Ø125 14EE1 D301
38 Ø90 DXF D301



3. Machine and Software Requirements

Machines:	6 axes CNC grinders : TAP NGM, dressing unit
Control:	Fanuc 31i B5
Coolant:	Synthetic Oil, pressure 9 bar
Software:	Quinto 5.4.6

responsible engineer: FFR,23.01.15

TECHNOLOGY FOR TOOLING

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